

Date: Thursday, 21/09/2006 11:14:50 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 3.540" OUTER TUBE, NO RIDGE (BO 105)
Job Number : 28672	
Estimate Number : 12465	
P.O. Number : N/A	Part Number : D2962150
This Issue : 21/09/2006 S.O. No. : N/A	Drawing Number : D2962 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 21/09/2006 Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 27774	Material : N/A
Written By : <u>W</u>	Due Date : 10/10/2006 Qty: 70 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est Rev:A New Issue 06-06-20 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 2097

C 206/09/21 (70)

- a) Extrude as per Dwg D2962
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 40 ksi
- e) Minimum elongation = 8%
- f) Order at 126" long 150"
- g) Bon L Canada Inc. tool # DAA-897127
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

2.0

D2962150P

3.540 Outer Tube, Extrut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 70.0000 Each(s)
 3.540 Outer Tube, Extrut

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

10/06/10/10 (82)
07/3/28 (70)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/05	30	Material is not rounded is very rough - see NCR	ASIAN	Return to supplier for replacement	U 07-30-05	07-03-05	ASIAN	07-03-05

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3.540" OUTER TUBE, NO RIDGE (BO 105)

Job Number: 28672

Part Number: D2962150

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per Dwg D2962

Check Pull test per Dwg D2962 for compliance page attached.

Check hardness with Webster tester

J070403
counted 87

PTO

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *E6*

J07-43

PTO

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

J07104105

Job Completion

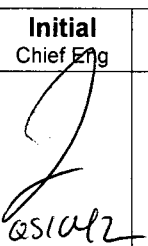





u J07-24-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070403	4.0	1 part is badly oxidized. no good for skid tube		surp. destroy	SB 7-4-3			

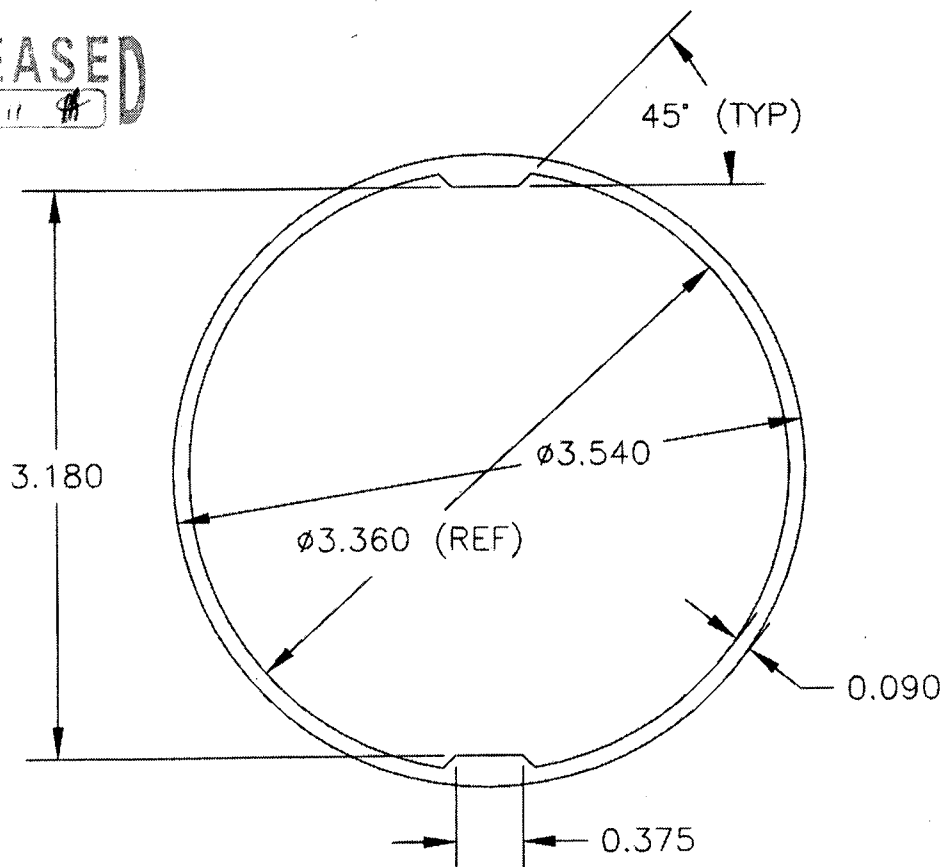
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2962	REV. A SHEET 1 OF 1
DATE 00.03.10		TITLE EXTRUSION	SCALE 1:1
A	00.03.10	NEW ISSUE	

RELEASED
00.05.11 [Signature]

REFERENCE ONLY



GENERAL NOTES

1. MANUFACTURED USING BON L CANADA DIE # T80- DAA-897127
2. ORDER AS D2962-XXX WHERE XXX = LENGTH IN INCHES
EG. 125 LONG: D2962-125
3. MATERIAL: 6061-T6 (QQ-A-200/8)
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

4. BREAK ALL UNMARKED SHARP CORNERS 0.016-0.025
5. NO TOOLING MARKS.
6. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
7. ALL DIMENSIONS ARE IN INCHES.

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CERTIFICATE OF COM

BON L CANADA INC

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Part Date	Part No.	Sales Order	Page
10/09/06	148499	41311	1
Part No.	B/L No.	Lot	Date
2097	00321502	41311010	10/09/06

Sold To	Ship To
48024	48024
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-3-2	150" MILL 6061 T6	D2962150
Gross Weight	603 KGS		
Net Qty	583 KG	82 PC	312 M 2 PKG

Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-00	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	329.7 / 47.8	298.7 / 43.3	11.1	.0	95

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.63	.25	.23	.07	.88	.08	.000	.02	.000	.000	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Ritchie Bisnauth, QA Manager Signed for Bon L Canada

See New C.O.C.
→

DRIVER/CAMIONNEUR



PLANT : PIC

TREDEGAR INDUSTRIES - ALUMINUM GROUP
RETURN PICKUPPAGE: 1
DATE: 3/22/07

Sold To:	Pick Up:
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1

RETURN NUMBER : 33099
SO NUMBER : 41311
PO NUMBER : 2097
INVOICE NUMBER: 10566863
PICKUP NUMBER :
PICKUP DATE : 03/05/07
DATE RECEIVED :CONTACT : Linda Lacelle
(PHONE) : 613 - 632-5200 (EXT)
ISR : Young, Joshua
CSR : Burton, Doris
INSTRUCTIONS :

Item	Part Number	Description	Kgs/Lbs	Pcs	Receiving		Disposition		
					Kgs/Lbs	Pcs	Scrap	Rework	List As Is
1.0	DAA-3-2	150" MILL 6061 T6	583/1285	82					
		STATUS : 30 - Pickup Assigned		CAR :					
		PLANT : RIH							
		PROBLEM: D.vanBakel has sample.PCs are oval and grooved.							
		COMMENT:							
		TOTAL:	583/1285	82					

*** Qtys subject to verification ***



CERTIFICATE OF COMPLIANCE

BON L CANADA INC

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Cert Date	Cert No	Sales Order	Page
03/26/07	157034	61219	1
Order PO	P/L No	Lot	Date
2097 REPLACEMENT	00338575	61219011	3/26/07

Sold To	Ship To
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-3-2	150" MILL 6061 T6	D2962150

Gross Weight	649 KGS
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Net Qty	601 KG	87 PC	331 M	4 PKG
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Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-00	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	327.6 / 47.5	302.8 / 43.9	10.3	.0	92
2	313.8 / 45.5	276.6 / 40.1	13.2	.0	96

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.65	.25	.24	.03	.89	.08	.006	.02	.000	.009	.01	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada